<b>Work Order ID</b> September-27-13 12:50:5			*107	7584*						Page 1	1
Item ID: D3255-5 Revision ID: Item Name: Gasket			Accept	*N900	<u>040</u>	100	)* s	etup Star Stop	I VI ,	S1* S2*	
Start Date: 9/27/13 Required Date: 9/27/13 Reference:	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item l Customer:	ID:				14	. 17	
T	Plan: MU	Date:  3-09-30			ate:		R	tun Star Stop	, "I <b>V</b> I	R1* R2*	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	<u>·</u>
D3255	Revision Nbr Rev B										
*1100* *1100* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo  1-Cut as p	per Dwg D3255	0.00	:			_8_	0_		JmB-	12-4
3355 Gadet	Dwg Rev: Prog Rev: 2-Deburr	_									
110 *410*	QC2- Inspect parts off		0.00				8			Tm 2	
QC Quality Control	Memo		0.00						<del></del>	<u>Jm13-</u>	12-4

		DQA:	Date:	
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	۱٥.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				İ	Descri	ption of work order update		nitial	Ac	tion	Sign &	•	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material												!	
Setup													
Other													
Process							1						
Supplier												1	
Training													
Unapproved													
					<del></del>	<del></del>	AUL	T CATE	GORY				
Landi	ng (	7				General		1		_	7	F	
	<u> </u>	Bending			<u> </u>	Bend	$\vdash$	Grain			Ovalized	-	Pressure/Forced
	<u> </u>	Centre No	ot Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		<u> </u>	Over/Under	<b>—</b>	Temperature/Cure
	_	Cracks			<u> </u>	Broken/Damaged	<b>—</b>	1 '	ion Incomplete		Part Incorre	H-	Weld
	_	Crushed/	Crimped		<u> </u>	Burrs	-	1	tions Incomplete/	Unclear	Part Lost/Mi		Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	$\vdash$	4	enance 		Part Moved		
	$\vdash$	Heat Trea			<u> </u>	Countersink	-	Mislabe		<u> </u>	Positioned V		7045
	<u> </u>	Inspectio	-	Tube	<u> </u>	Cut Too Short	$\vdash$	Misrea	đ	<u> </u>	Power Loss/	Surge	Other
		Ripples ir			<u> </u>	Drill Holes	$\vdash$	Offset	California de				
		Torque W			n	Drawing	$\vdash$	4	Calibration				
1	1	Turning S	equence	1		Finish	1	JUUT OF	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Orde September-27-1.				*107	584*						Page 2
Item ID: Revision ID: Item Name:	D3255-5 Gasket	and the second s		Accept	*N900	040 <i>′</i>	100	* s	Setup Star Stop	ıv.	S1* S2*
Start Date: Required Date: Reference:	9/27/13 9/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:					
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ite:		F	Run Star Stop	" <b>iV</b> i	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	and check	Set Up/ Run Hours 0.00 27 9-89 0.00 3	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		ldentify as per dwg & Sto	ock Location:	0.00				8×	DAS 28 9-89	13-12-	- <del>4</del>
140 * <b>110</b> *		QC21- Final Inspection -	- Work Order Release	0.00					131	12/9	44

0.00

Memo

Quality Control

1/12/12

DQA:	Date:		

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

										QA Closed:	Dat	e:
Work Orde	r·				DISPOSITION				AGAINST DI	EPARTMENT,	PROCESS	
Part N NCR N	0.				Rework Scrap Use-as-is Work Order Update		1	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									<del> </del>			
quip/Tooling												
Operator												
Material												
Setup												
Other												
Process		į										
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raining [												
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					F	AUL	T CATE	GORY				
Landin	g Gear				General	_			_	_	,	
	Bending			L	Bend	Ш	Grain		_	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		_	Over/Under		Temperature/Cure
1	Cracks			_	Broken/Damaged		-	ion Incomplete	_	Part Incorred		Weld
	Crushed/	'Crimped			Burrs	-		tions incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
]	Cuffs				Contamination	$\vdash$		enance		Part Moved		
	Heat Trea	at			Countersink	Ш	Mislabe	eled	<u></u>	Positioned V		<del></del>
ļ	Inspectio	•	Tube	<u> </u>	Cut Too Short	$\vdash$	Misrea	d	L_	Power Loss/	Surge	Other
	Ripples in			<u> </u>	Drill Holes	-	Offset					
	Torque V			n  _	Drawing	$\vdash$		Calibration				
	Turning S			L	Finish	$\vdash$		Sequence				
	Wave/Tv	vist in Tul	be		Folio		Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

September-27-13 12:50:52 PM

Work Order ID:

107584

Parent Item:

D3255-5

Parent Item Name:

Gasket

**Start Date:** 9/27/13

Required Date: 9/27/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A04.05.12New issueKJ/RF

IPP Rev:B Now On Waterjet 06-08-14 JLM

	11 1 110 112 110 11			·										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D3255		Manufactured	No			110	sf	36.0000	1.5411	-9 <del>.733263</del>	<b>+</b>			
Gasket									Ch. when		Sq. F1		3	47-Y

 Location
 Loc Oty
 Loc Code

 MAT052
 36
 99492
 36

•		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

												QA Closed:	Dat	:e:	
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
Part N	-					Rework Scrap Use-as-is Work Order Update	1	Machining Small Fab Prod. Eng. Coor. Qual					Engineering Quality Other		
Root					Descri	ption of work order update	Init	tial	Ac	tion	[	Sign &		$\Box$	
Cause		Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	cription		Date	Verification	n	QC Inspector
Doc/Data														$\Box$	
Equip/Tooling							ļ								
Operator							1							ļ	
Material															
Setup															
Other											ļ				
Process	Ш														
Supplier	Ш														
Training	Ш														
Unapproved	Ш						<u> </u>								
							AULT	CATE	GORY						
Landi	_				_	General						1	•		
	${f m H}$	Bending			<u> </u>	Bend	-	rain			-	Ovalized		ot	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		ardwa			-	Over/Under		<u> </u>	Temperature/Cure
	${f H}$	Cracks			<u> </u>	Broken/Damaged	-		on Incomplete		<b></b>	Part Incorred	1	-	Weld
	$\vdash$	Crushed/	Crimped		<u> </u>	Burrs	-		ions Incomplete	/Unclear	-	Part Lost/Mi	ssing	لـــا	Wrong Stock Pulled
	$\vdash$	Cuffs			<u> </u>	Contamination	$\mathbf{H}$		enance		-	Part Moved			
	$\vdash$	Heat Trea			-	Countersink	$\vdash$	lislabe 			$\vdash$	Positioned V	_	$\overline{}$	0.45
	_	Inspection		Tube	-	Cut Too Short	$\vdash$	lisread	1		Ш	Power Loss/	Surge		Other
	$\vdash \vdash$	Ripples in			-	Drill Holes	$\vdash$	ffset	Salikaani aa				<del> </del>		
	$\vdash$	Torque W			n	Drawing	$\mathbf{H}$		Calibration			····	<del></del>		
Turning Sequence Finish			Out of Sequence												
Wave/Twist in Tube Folio			l lo	utside	Dimensions										

DART AEROSPACE LTD	Work Order:	107574
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST **Prototype First Article Drawing** Actual Method of **Tolerance** Accept Reject Comments Inspection **Dimension Dimension** 1.00 +/-0.030 1.000 V Jemus 18.46 +/-0.030 13.46 11.43 +/-0.030 1 15.36 +/-0.030 15.36" 7 6.90 +/-0.030 0.063 +/-0.010 0063 DAS 27 Measured by: Audited by: **Prototype Approval:** JIM N/A 9-89 13-12-4 Date: Date: Date: N/A Revised by Rev Date Change Approved

KJ/JLM A

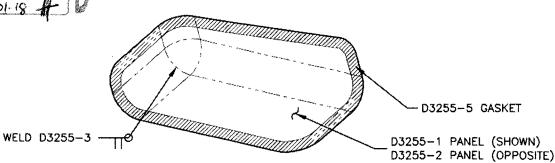
07.07.18 New Issue



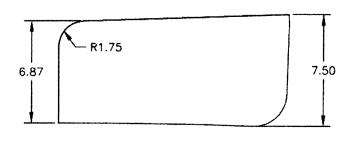
	DESIG	₩ A	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD			
	CHEC	CED /	APPROVED	DRAWING NO.		REV.	В
:		W	#	D3255	SHEET	1 OF	4
	DATE			TITLE	***************************************	SCA	LE
	04.1	2.06		ACCESS PANEL ASSEMBLY		1	1:6
	Α		04.01.27	NEW ISSUE			
			<del></del>		<del></del>	<del></del>	*************

04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098

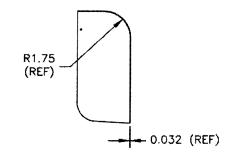


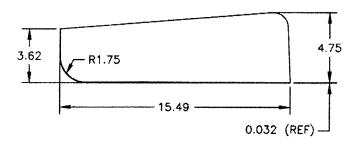


### D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



В





D3255-1 BEND DETAIL D3255-2 OPPOSITE

### D3255-041/-042 NOTES:

- WELD PER DART QSI 004
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

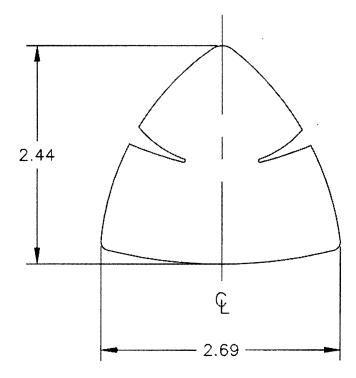
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CHECKED (	APPROVED	DRAWING NO. D3255	REV. B Sheet 2 of 4
DATE	1 40	TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

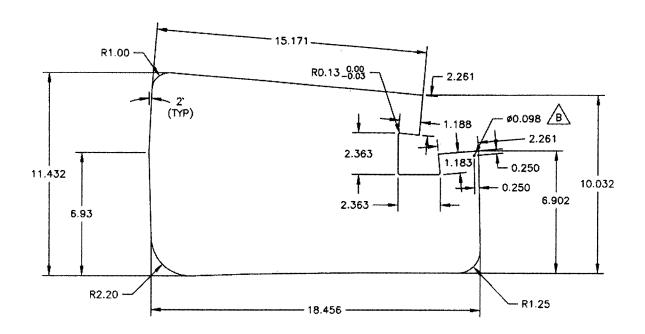
### D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
4	1 #	D3255	SHEET 3 OF 4	
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:5	





# D3255-1/-2 FLAT PATTERN

### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

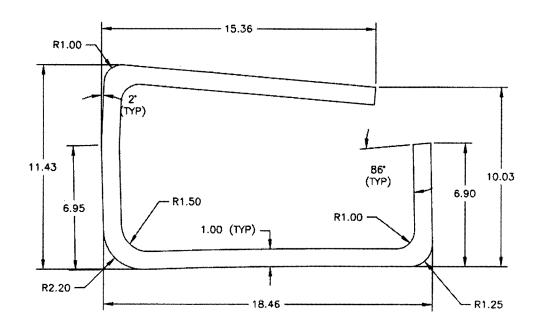
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CHECKED (	APPROVED.	DRAWING NO. D3255	SHEET	REV. 4 OF	_
DATE		TILE		SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY		1	1:5





### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16
- POSSIBLE SUPPLER: AVIALL
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  3) ALL DIMENSIONS ARE IN INCHES

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